

Aero Design Ltd.**Work Order Control Sheet**Work Order#: 2017-64 Date Opened: 11 April 17 Title: FabricationAircraft OEM: Bell Aircraft Model: 205/212 Product Type: Cargo Deployment Arm Product Model: Bushings Quantity: 1/1**Work Order Contents**

Work Order/Build Sheets (Procedures Provided)
Additional Work Sheets (Standard Practice)
Drawings (See List Below)
Parts Distribution Sheet
Sub Component Tags
Completed Certification
Time Sheet (R&D)
Notes

Initial or N/A

JC
N/A
JC
N/A
N/A
JC
N/A
N/A

Build Sheet Contents

Tasks Initialled
Dual Inspections Initialled

Initial or N/A

JC
N/A

Drawing List

Drawing #	Rev #	Description	Initial or N/A
79237	1	Bushings	JC

Component Completion

Quantity Complete on This Work Order
Quantity Incomplete on This Work Order
Further Processing Required Before Release
Release to Stock as Components

As Instructed

1/1
N/A
N/A
N/A

Certification

Form One Completed
Serviceable (Green) Tag Completed
In Process (Yellow) Tag Completed
Unserviceable (Red) Tag Completed
Parts Placed in Stores for Distribution

Initial or N/A

JC
N/A
N/A
N/A
N/A

Additional Documentation

Documentation of a minor change
Non-Conformance Report Required
Service Difficulty Report Required

Initial or N/A

N/A
N/A
N/A

Billing

Local (Aero Design)
Research and Development
Third Party

Initial or N/A

JC
N/A
N/A

Traveller

Initial or N/A

Work performed by:

ICC / Dual Inspection performed by:

Work Order closed by:

Form 20.D.03

Print: J. ClarkePrint: N/APrint: J. Clarke

Rev. Original 23 Sep 2014

Sign: JJCSign: JJCSign: JJCSCA: AD02SCA: SCA: AD02Date: 14-Apr-17Date: Date: 14-Apr-17

2017-64

REV.	DESCRIPTION OF CHANGE	INITIALS	DATE
0	INITIAL ISSUE		
1	ADDED FIT TOLERANCE	RR	30/12/08

1 each

 $\phi 0.375^{+0.003}_{-0.000}$
LIGHT INTERFERENCE FIT
WITH MATING PARTDRILL "F" ($\phi 0.257$) THRU

0.265

(01) BUSHING

 $\phi 0.375^{+0.003}_{-0.000}$
LIGHT INTERFERENCE FIT
WITH MATING PART $\phi 0.63$ DRILL "F" ($\phi 0.257$) THRU

0.365

0.063

(02) BUSHING

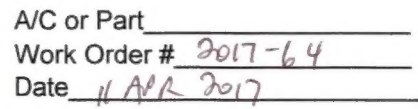
NOTES

1. REMOVE ALL BURRS AND BREAK SHARP EDGES.

79237-02	02	BUSHING	BRASS ROD		$\phi .63$ MIN
79237-01	01	BUSHING	BRASS ROD		$\phi .38$ MIN
PART NO.	ITEM	DESCRIPTION	MATERIAL	MATERIAL SPEC	STOCK SIZE

LIST OF MATERIALS

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	DRAWN:	R. RATHWELL	22/04/08						
	CHECKED:	E. BURGAIN							
	UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES. TOLERANCES ON:				BELL 212, 412, 205A-1, 205B CARGO DEPLOYMENT ARM BUSHINGS				
	DECIMALS		ANGLES						
X.XXX ±0.010		±1/2°							
	X.XX ±0.03				SCALE 1 : 1		DWG. SIZE	DWG. NO.	REV.
	X.X ±0.1				SHEET 1 OF 1		A4	79237	1

Rev. Original 1 Mar 2013

BUSHING/TUBE/GUIDE/THREADED LUG

General

These general instructions apply to bushings, tubes and similar round components used for Aero Design cargo baskets, mounting beams, and other products. Refer to the drawing, at the current revision, for dimensions and details. Selected drawings with applicable parts, drawings not listed may also apply:

69830 – Bell 206L/407 Mounting Beam
76630 – Bell 206L/407 High Mounting Beam
78633 – Airbus AS350 Aft Beam
78634 – Airbus AS350 Forward Beam
49215 – Lid Prop Bushing
49216 – Lid Prop Bushing

76423 – Airbus AS350 Attachment Hoop
94023 – Airbus AS350 XL Attachment Hoop
82715 – Airbus AS350 Short Step Assembly
82733 – Airbus AS350 Short Step Bracket
36274 – Handle Lever Bushing
36275 – Handle Support and Bushing

Work Order: 2017-64

Batch Quantity: 1

Complete
(initial or SCA #)

Date Open: 11 APR 2017

Part Number: 79237-01

AD
73-04
02

1. Cut stock material:

- Enter material PO:
- Cut stock to length, + 0.03-0.06".
- Tag in-progress parts and place on in-progress shelf in machine shop.

PO: 13050
φ3/8 Brass rod
AD
73-04
02

2. Turn stock material:

CAUTION: Using a lathe requires training and is not to be undertaken without adequate instruction and knowledge of the processes and settings involved. Do not attempt to fabricate parts on the lathe if you are unsure of what is required to safely produce the part.

Note: Not all steps may apply to all parts. Strike out any step(s) that does not apply.

Note: Feeds and speeds are recommended starting point for aluminum, steel, and stainless steel up to 1" in diameter using the appropriate inserts. Adjust for optimal performance and finish.

- Face one end flat @ 1000 RPM, cross feed @ 0.01"/rev roughing, 0.004"/rev finishing.
- Turn outside @ 1000 RPM, feed @ 0.01"/rev roughing, 0.004"/rev finishing.
- Centre drill and drill at 300 RPM (up to 5/16", reduce for larger sizes).
- Setup stop and face other end to length @ 1000 RPM.
- De-burr outside with a file and inside with a de-burring tool at 300 RPM.
- Tag complete parts.

BUSHING/TUBE/GUIDE/THREADED LUG

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Work Order: 2017-64

Batch Quantity: 1

Complete
(initial or SCA #)

Date Open: 11 APR 2017

Part Number: 79237-02

AD
73-04
02

1. Cut stock material:

- Enter material PO:
- Cut stock to length, + 0.03-0.06".
- Tag in-progress parts and place on in-progress shelf in machine shop.

PO: 17017
φ5/8 brass rod

AD
73-04
02

2. Turn stock material:

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- De-burr outside with a file and inside with a de-burring tool at 300 RPM.
- Tag complete parts.

1. Approving Civil Aviation Authority/Country Transport Canada		2. AUTHORIZED RELEASE CERTIFICATE FORM ONE			3. Form Tracking No. 2017-0150
4. Organization Name and Address AERO Design Ltd. – 9888A Malaspina Road, Powell River, BC, V8A 0G3					5. Work Order/Contract/Invoice WO 2017-64
6. Item	7. Description	8. Part Number	9. Qty.	10. Serial/Batch No.	11. Status/Work
1.	Bushing	79237-01	1	NSN	New
2.	Bushing	79237-02	1	NSN	
12. Remarks					
13a. Certifies that the items identified above were manufactured in conformity to: <input checked="" type="checkbox"/> Approved design data and are in condition for safe operation. <input type="checkbox"/> Non approved design data specified in block 12.			14a. <input type="checkbox"/> CAR 571.10 Maintenance Release <input type="checkbox"/> Other regulation specified in block 12 Certifies that unless otherwise specified in block 12, the work identified in block 11 and described in block 12, has been performed in compliance with the Canadian Aviation Regulations.		
13b. Signature  AD 73-04 02		13c. Approved Organization Number AMF 73-04		14b. Signature	
13d. Name Jeff Clarke - AD02		13e. Date (dd/mm/yyyy) 14 Apr 2017		14c. Approved Organization Number	
				14d. Name	
				14e. Date (dd/mm/yyyy)	
<p style="text-align: center;">Installer Responsibilities</p> <p>This certificate does not constitute authority to install.</p> <p>Installers working in accordance with the national regulations of a country other than that specified in block 1 must ensure that their regulations recognize certifications from the country specified.</p> <p>Statements in blocks 13a or 14a do not constitute installation certification. In all cases, the technical record for the aircraft must contain an installation certification issued in accordance with the applicable national regulations before the aircraft may be flown.</p>					

WILD CAT HELICOPTERS